

# Work Order ID 54842

December 29, 2009 8:26:48 AM

Page 1

Item ID: D412-698-023

Accept

Setup Start

Revision ID:

Item Name: Automatic Door Opener, LH/RH

Stop

Start Date: 12/30/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *09-12-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

*Solodov*

*AJ for BG 10/01/07*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*10-1-7 3x 54*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*2 Solodov*

*(x3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D412-698-023

Accept



Setup Start



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Item Name: Automatic Door Opener, LH/RH

Stop



Start Date: 12/30/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-698-023  
Location: \_\_\_\_\_ PPP Rev: \_\_\_\_\_

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/07 (3)

10/01/07

MF  
10-01-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Page 1

Work Order ID: 54842

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/30/2009

Required Date: 1/13/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD516L

f2

Purchased

No

120

Each

201.0000

8.0000



Washer

10-1-7 sl

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

201

112466

180

14477

18

17619

3

D3552-11

t1

Manufactured

No

120

Each

37.0000

4.0000



Door Prop

10-1-7

sl (34)

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

Return 2009

26

53713

26

Main Warehouse

ST

11

42606

6

46631

3

52940

2

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 54842

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/30/2009

Required Date: 1/13/2010

Comments:

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Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3594-043		Manufactured	No			120	Each	3.0000	4.0000			
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Floor Doubler Assembly, LH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

48255

3

D3594-044

Manufactured No

120

Each

8.0000

4.0000



Floor Doubler Assembly, RH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

53715

8

D3594-5

Manufactured No

120

Each

23.0000

4.0000



Door Doubler

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

53716

21

Main Warehouse

ST234A

2

50115

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 3

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Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/30/2009

Required Date: 1/13/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3622-1

x2

Manufactured

No

120

Each

25.0000

8.0000



Ball Stud

10-1-7 sl

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

52287

5

53718

20

MS20426AD4-4

x2

Purchased

No

120

Each

2,673.000

8.0000



Rivet

10-1-7 sl

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2673

15541

2673

MS21073L5

x1

Purchased

No

120

Each

18.0000

4.0000



nut plate

10-1-7 sl 34

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

112314

18

3

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

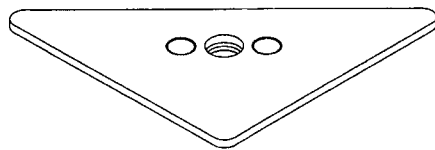
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

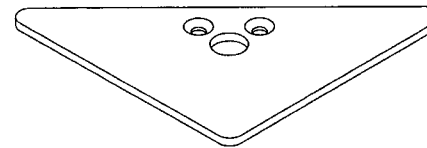
NOTE: Date & initial all entries

## 7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

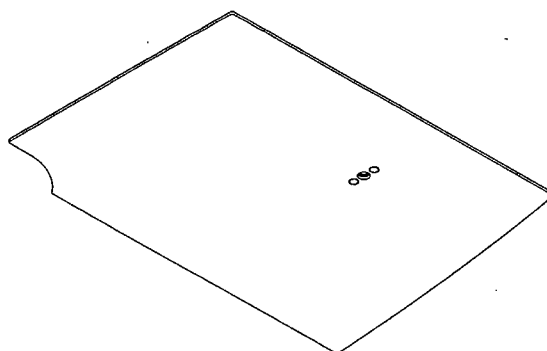
Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW



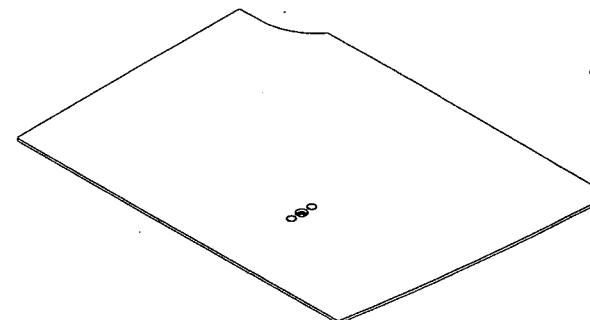
**D3594-041 DOOR DOUBLER ASSEMBLY**



**D3594-5 DOOR DOUBLER**



**D3594-043 FLOOR DOUBLER ASSEMBLY**



**D3594-044 FLOOR DOUBLER ASSEMBLY**

54840

RELEASED  
08.05.14

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	